

Work Order ID 75010

75010

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October-17-11 9:06:49 AM

Item ID: D2873-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 17/10/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 31/10/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								

100 BAND SAW 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blanks: 1.000" x 0.375" x 3.700" long

Good 11-10-20 20 ✓

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3
 Dwg Rev A Folio Rev A

Good 11-10-20 20 ✓

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.00
 Quality Control

Good 11-10-20 20 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>on 11/10/20</i>		<i>20</i>	<i>0</i>		
140 *140* Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00 0.00							<i>20</i> <i>11/10/24</i>
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8 ul 1/26</i>		<i>counts</i> <i>20</i>			

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-043								

20 BL 11-10-26

EP 11/10/31 (20)

EP 11/10/31 (20)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>10</u>	<u>11</u>	<u>10</u>	<u>31</u> (20)
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>x tube</i> <i>any</i> Memo	0.00 0.00				<u>25</u>	<u>11</u>	<u>-11</u>	<u>-01</u> (x20)
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/11/02</u> <i>J</i>

MF
11-11-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 75010

75010

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 17/10/2011

Required Date: 31/10/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

26.0000

3

60

MS21075L5

Nut Plate

**

Location

Loc Qty

Loc Code

ST303

26

116914

1

118542

25

M6061T6B0.375X01.00

Purchased

No

180

f

24.7600

0.3083

6.490526

0

M6061T6B0.375X01.000

6061T6 BAR .375 x 1.00

**

Location

Loc Qty

Loc Code

MAT

24.76

113325

0

118641

24.76

MS20426AD4-6

Purchased

No

180

Each

561.0000

6

120

MS20426AD4-6

Rivet

**

Location

Loc Qty

Loc Code

GA

154

118510

154

ST317

407

110139

201

117505

206

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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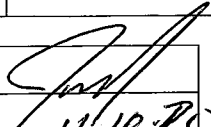
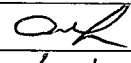
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	75010
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓		Amv6	
2.000	+/-0.010	1.998	✓		" "	
0.750	+/-0.010	.749	✓		" "	
1.000	+/-0.010	.999	✓		" "	
0.250	+/-0.010	.2495	✓		" "	
1.000	+/-0.010	1.001	✓		" "	
2.000	+/-0.010	2.004	✓		" "	
3.000	+/-0.010	3.004	✓			
Ø.128	+0.005/-0.001	Ø.131	✓		" "	
0.359	+/-0.010	.361	✓			
Ø.316	+0.006/-0.001	Ø.319	✓		" "	
1.000	+/-0.010	1.001	✓			
0.250	+/-0.010	.248	✓			
0.061	+/-0.010	.063	✓		" "	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .127	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/10/20	Date:	11/10/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM 	

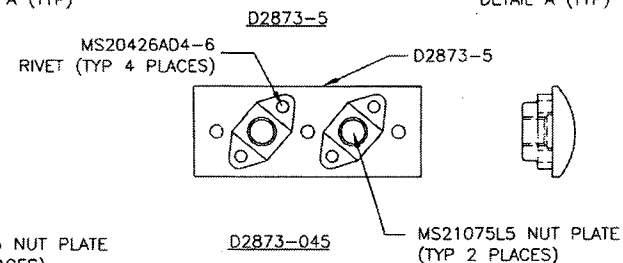
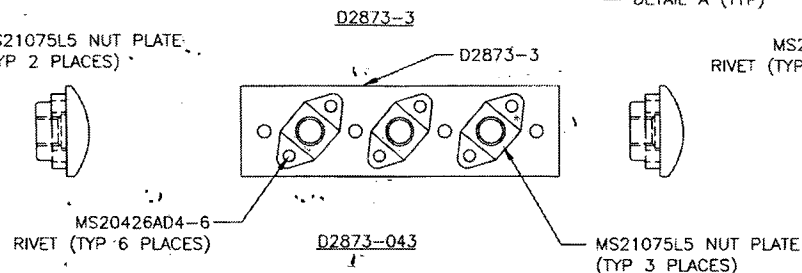
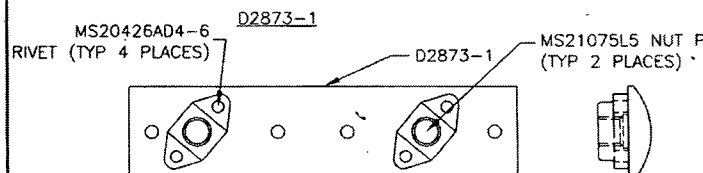
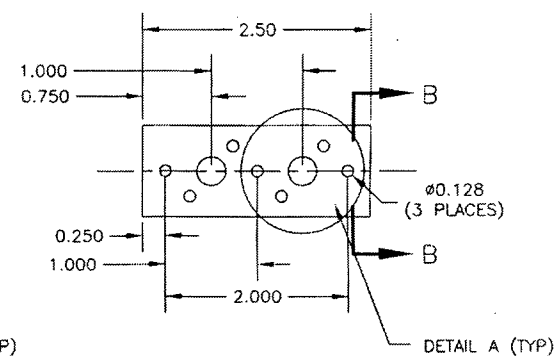
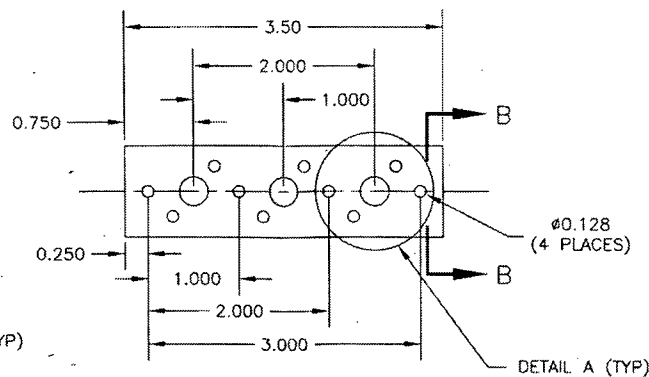
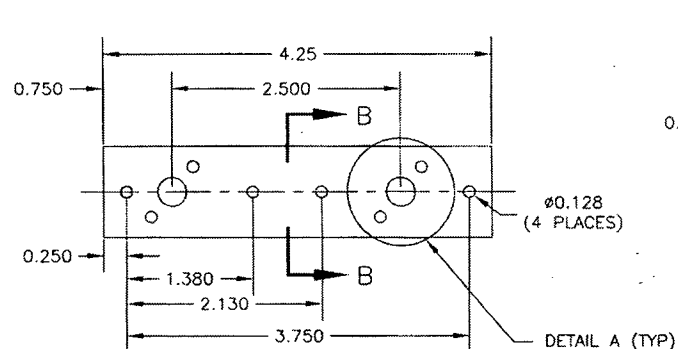
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NOTE: Date & initial all entries



D2873-041

D2873-1/-3/-5 RADIUS BLOCK

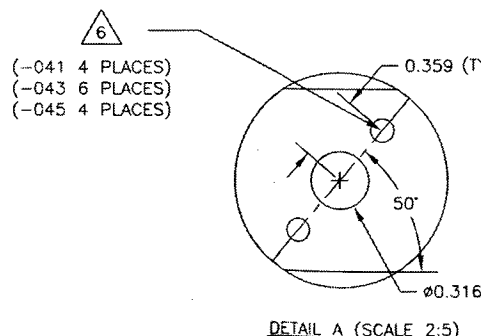
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

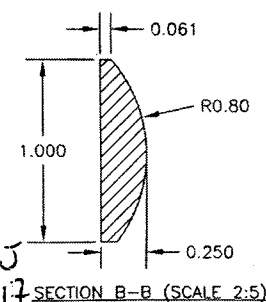
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 75010



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5

RELEASED
05/07/26

W/O:		WORK ORDER CHANGES					
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